

Date: Wednesday, 9/13/2006 4:32:47 PM
User: Kim Johnston

Process Sheet

Split SS 06/10/10

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHUT-OFF VALVE ASSEMBLY
Job Number : 28538	
Estimate Number : 12186	
P.O. Number : <i>NIA</i>	Part Number : D3469041
This Issue : 9/13/2006 S.O. No. : <i>NIA</i>	Drawing Number : D3469 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 26954	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i> 06 09 14	
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3469043	TUBE ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3469-043	Tube Assembly	<i>B28556</i>

2.0	D3470041	SHUT-OFF VALVE SHAFT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3470-041	Shut-Off Valve Assembly	<i>B28557</i>

3.0	D34705	PLATE VALVE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D3470-5	Plate Valve	<i>B26116</i>

4.0	D34707	valve seal
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3470-7	Valve Seal	<i>B26988</i>

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Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34709

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch:

B2438

6.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN310-4 Nut M19096

7.0

AN9604L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-4L Washer M14606

8.0

AN960416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-416 Washer M5519

9.0

MS24665153

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

COTTER PIN

Batch:

M19096

10.0

MS35206217

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS35206-217 Screw M13883

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 28538

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS679A04

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS679-A04 Nut M100546

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469

unf. 06/10/16 - ①

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure Unit Opens and Closes Smoothly

Job 10-17 ①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: A

HA

u

15.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2006/10/17

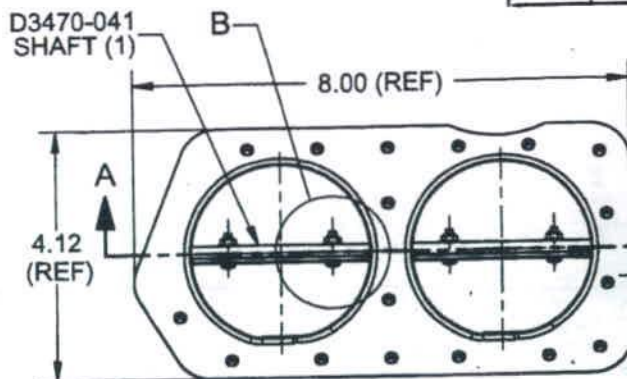
Job Completion



u 10-17

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED B.O.M. on PAGE 2	

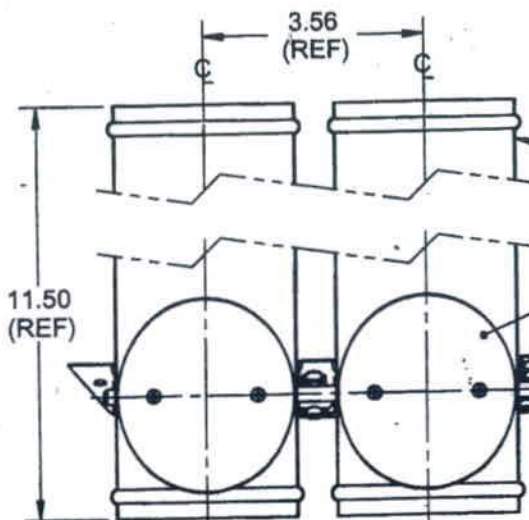
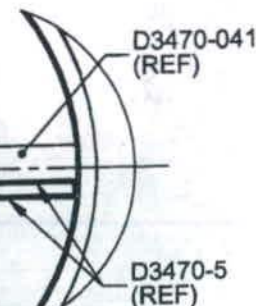


MS35206-217 SCREW
AN960-4L WASHER
NAS679-A04 NUT
(4 PLACES)

D3470-7
BUTTERFLY
VALVE SEAL
(2 PLACES)

MS24665-153
COTTER PIN (1)

DETAIL B
SCALE 1:1



SECTION A-A

06.04.20 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28538

D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

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